

Work Order ID 84539

May 15, 2012 1:59:11 PM

Non Eurocept

84539

Page 1

Item ID: D350-591-311

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

NS2

Start Date: 5/15/12

Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/25/12

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: *CL*

Date: *12/05/15* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

CHG002

8.2/6/15

JJ 401 ML5 12-6-13
(5)

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod

3-Grind End Plate flush

119785
120834

5 *φ* *12.05.16*

Ac
12.05.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop

NS2

Start Date: 5/15/12 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/25/12 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC Memo

0.00

Quality Control

5 0 BEU/06/05

130 QC5- Inspect part completeness to step on W/O

0.00

130

QC Memo

0.00

Quality Control

5/17/06/05

5 4

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish Memo

0.00

Hand Finishing

5 MB 12-6-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D350-591-311

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 5/15/12 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/25/12 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				5x			<i>[Signature]</i> 6/06/07
150									
QC	Memo	0.00							
Quality Control									
180		0.00				5	0		<i>Ae</i>
180	Large Fab								12.06.07.
Large Fab	Memo	0.00							12.06.08
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod <u>120854</u>								<i>Ae</i> 12.06.11
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

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Item ID: D350-591-311 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step, Long LH
 Start Date: 5/15/12 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 5/25/12 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				X5 HT			
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							(S) MG 12-6-12

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Item ID: D350-591-311

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long LH

Start Date: 5/15/12 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/25/12 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 11:30	0.00							
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 12:00								
230	Wing Walk as per dwg QSI005 4.4 Batch 12103	0.00							
230									
HandFinish									
Hand Finishing									
	Memo								
240	QC3- Inspect Part Finish	0.00							
240									
QC									
Quality Control									
	Memo								

Work Order ID 84539

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Item ID: D350-591-311

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 5/15/12 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 5/25/12 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00				5x			SP 12-6-14
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00		5/26/15					(C) LTC
Quality Control									
270		0.00							
270									
Packaging	Packaging	0.00							
Packaging	Memo	0.00				5x			SP 12-6-18
Packaging	Identify and pack for shipping as per PPPD350-591-311								
	Location: <u>D</u>								

Work Order ID 84539***84539***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long LH

Start Date: 5/15/12 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/25/12 Req'd Qty: 5.00

5

Customer:

Reference:

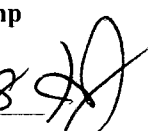
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

12/6/18 

MF
12-06-18

Picklist Print

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Page 1

Work Order ID: 84539

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 5/15/12

Required Date: 5/25/12

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
route seq in bom DD 10.04.28 verified by:EC

IPP Rev:D fixe

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1 Step		Manufactured	No			110	Each	30.0000	1	5		12.05.05	
-----------------	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--

Location

Loc Qty

Loc Code

ST	-10	
WA	40	
83729	10	
83731	10	
83778	10	

5

* D3067-1
End Plate

Manufactured No

110 Each 97.0000

1 5

12.05.16

Location

Loc Qty

Loc Code

WA	33	
78608	4	
81969	29	
WA016	64	
67582	2	
68214	1	
79607	1	
83053	60	

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 84539

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 5/15/12

Required Date: 5/25/12

Start Qty: 5.00

Required Qty: 5.00

✓ D3219-1 Manufactured No

110 Each 233.0000

2 10

12.05.16

Plate

Location

Loc Qty

Loc Code

WA
82221
WA016
73410
77674
81292
WA017
81971

74
74
38
12
6
20
121
121

10

✓ D3066-1 Manufactured No

180 Each 131.0000

2 10

12.06.07

Spacer

Location

Loc Qty

Loc Code

ST176
83854
WA
81968

120
120
11
11

10

* MS20600-AD4W4 Purchased No

180 Each 3,324.0000

16 80

Rivets

Location

Loc Qty

Loc Code

321
121652
ST321
121011
121340
121444

1000
1000
2324
9
315
2000

121652 → 80
12.06.07

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 84539

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 5/15/12

Required Date: 5/25/12

Start Qty: 5.00

Required Qty: 5.00

D3065-041
Step Leg Assembly Hi

Manufactured No

180 Each 43.0000

1 B838⁵70 → 5
Ao 12.06.07

Location	Loc Qty	Loc Code
WA	43	
66149	0	
79336	1	
80880	26	
83368	16	

D3067-1
End Plate

Manufactured No

180 Each 97.0000

1 5 12.06.08

Location	Loc Qty	Loc Code
WA <u>B83255</u>	33	
78608	4	
81969	29	
WA016	64	
67582	2	
68214	1	
79607	1	
83053	60	

AN8-65A
Bolt

Purchased No

250 Each 216.0000

2 10 u

Location	Loc Qty	Loc Code
ST353	216	
120644	16	
120717	50	
121652	150	

D3235-1
Mounting Lug

Manufactured No

250 Each 89.0000

2 10 B83311 80
12-6-14.

Location	Loc Qty	Loc Code
ST481	89	
81970	89	

DSZ0410-011 CHC742 B 85647 Dec 14. at x1

(12/6/10/5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 84539

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 5/15/12

Required Date: 5/25/12

Start Qty: 5.00

Required Qty: 5.00

D3278-041
Support Assembly

Manufactured No

250 Each 43.0000

0 **B 23856 SP**

Location	Loc Qty	Loc Code
ST481	43	
82015	40	
83361	3	

AN960JD416
Washer

NAS1149D0463J Purchased No

250 Each 30.0000

16 **80** **m12912 SP**

Location	Loc Qty	Loc Code
ST351	30	
116289	10	
119097	20	

AN960JD516
Washer

NAS1149D0563J Purchased No

250 Each 0.0000

4 **80** **m129546 SP**

AN5-36A
Bolt

Purchased No

250 Each 264.0000

2 **80** **10**

Location	Loc Qty	Loc Code
340	200	
121181	100	
121652	100	
ST340	64	
120731	14	
121708	50	

D2618
Bushing

Manufactured No

250 Each 205.0000

2 **80** **10** **12-6-14**

Location	Loc Qty	Loc Code
ST012	205	
76130	2	
80474	126	
83614	77	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 84539

Parent Item: D350-591-311

Start Date: 5/15/12

Required Date: 5/25/12

Parent Item Name: Heli-Access-Step, Long LH

Start Qty: 5.00

Required Qty: 5.00

D2230-3 Manufactured No 250 Each 170.0000

Lug

Location Loc Qty Loc Code

ST480 170

81962 170

D2856-400 Manufactured No 250 f 305.5345

Abrasion Strip

*** cut (2) at 7.20" (D2856-400-720) ***

Location Loc Qty Loc Code

ST403 216

81875 216

ST409 89.5345

63735 0.6696

68076 0.3149

71164 8.46

79551 80.09

MS21042L3 Purchased No 250 Each 2,757.0000

Nut

Location Loc Qty Loc Code

ST300 2757

117885 32

119017 1114

119075 138

121349 522

121444 951

AN4-13A Purchased No 250 Each 1,673.0000

Bolt

Location Loc Qty Loc Code

ST357 1673

119449 33

120187 19

120422 2

120770 400

121162 219

121652 1000

B832618x
B8413312x

1.2 6P

6x

2 10 8P

10x

8 40 12-6-14

10x

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 5/15/12

Required Date: 5/25/12

Start Qty: 5.00

Required Qty: 5.00

MS21042L5

Nut

Purchased

No

250

Each

1,554.0000

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

1054

116105

5

116548

43

117611

18

119109

988

MS21042L4

Nut

Purchased

No

250

Each

5,030.0000

Location

Loc Qty

Loc Code

ST300

5030

119075

233

121011

1534

121444

2963

121652

300

AN260JD10

Washer

NAS1149D0363J

Purchased

No

250

Each

0.0000

2 10 SP

8 10x 40 SP

4 20 m121524 SP 12-6-14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN <i>9P</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

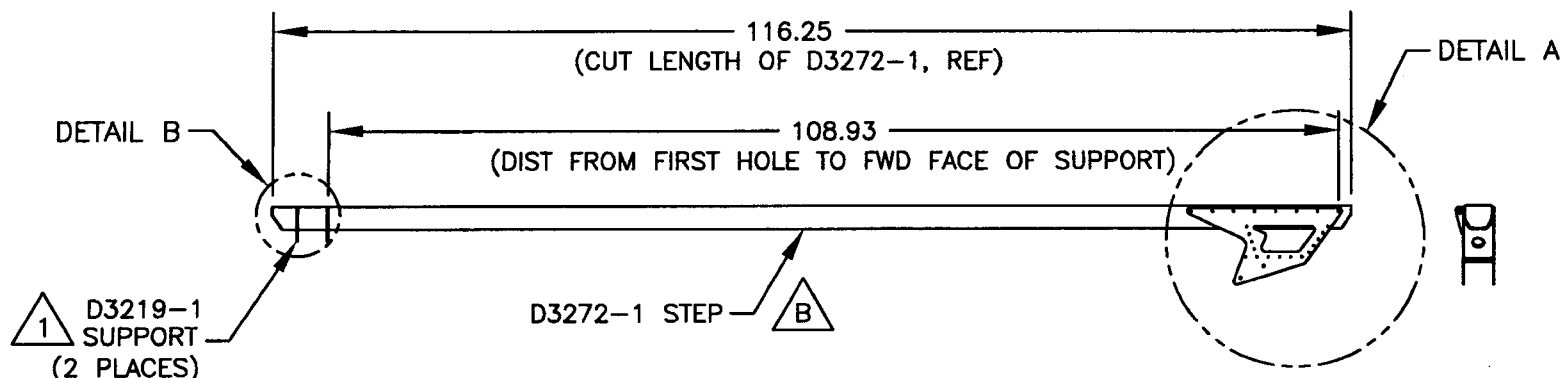
CL 12/05/15

W10: 84539

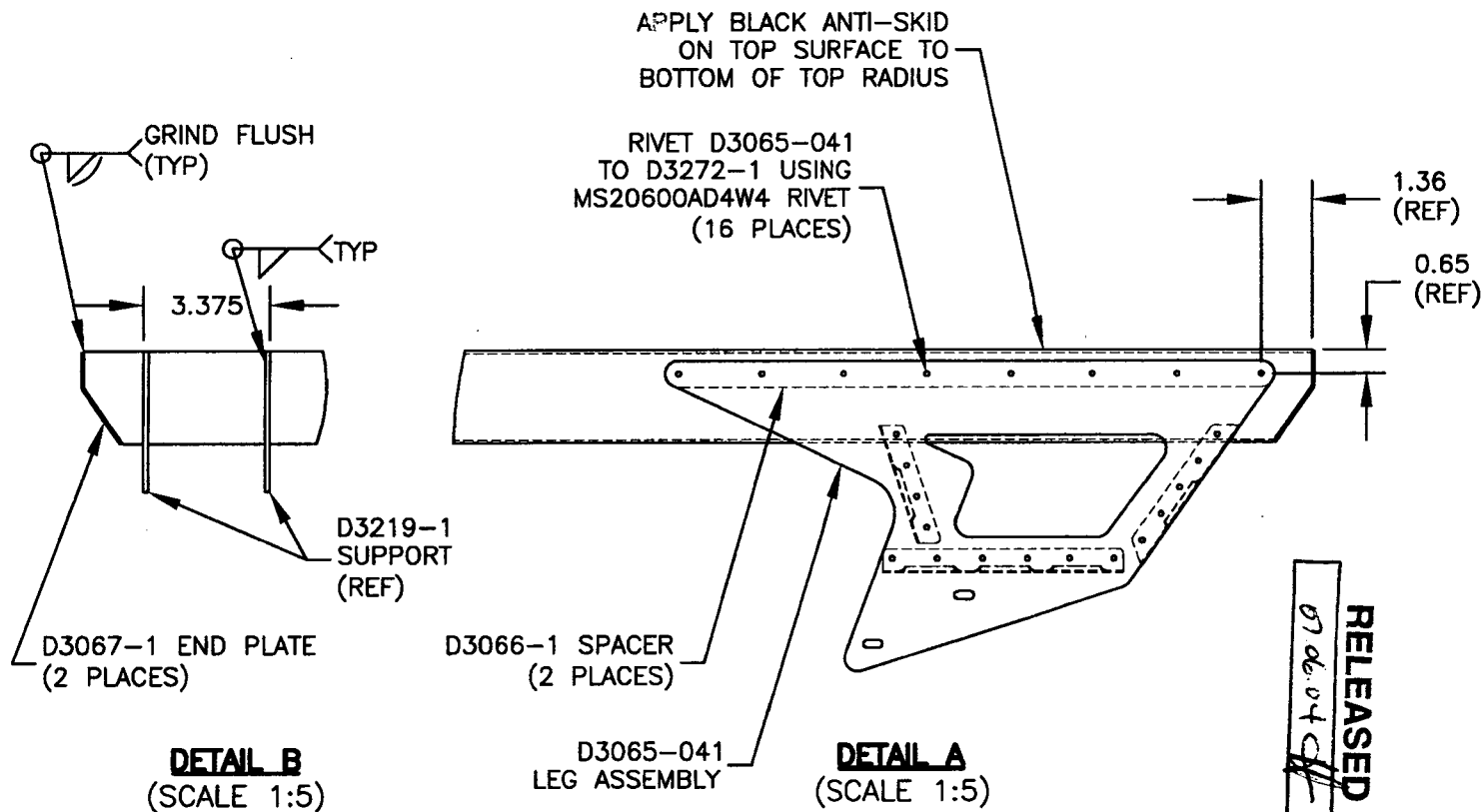
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DART



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



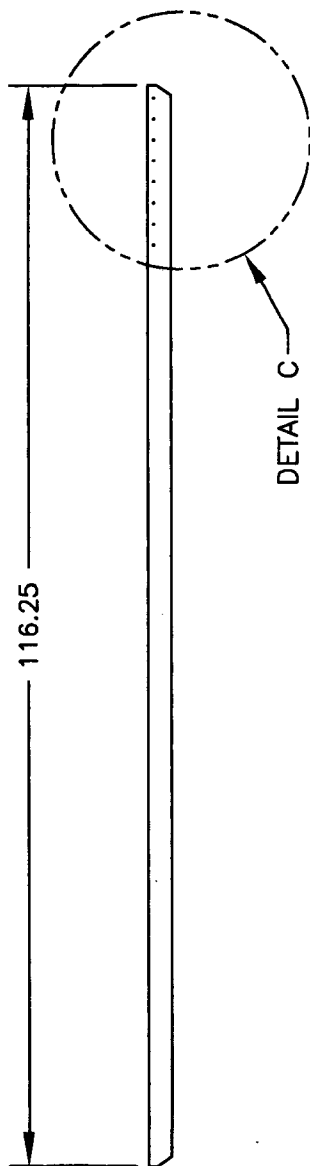
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 3
DATE	TITLE	STEP ASSEMBLY, HI LONG	SCALE
07.05.18			1:20



DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

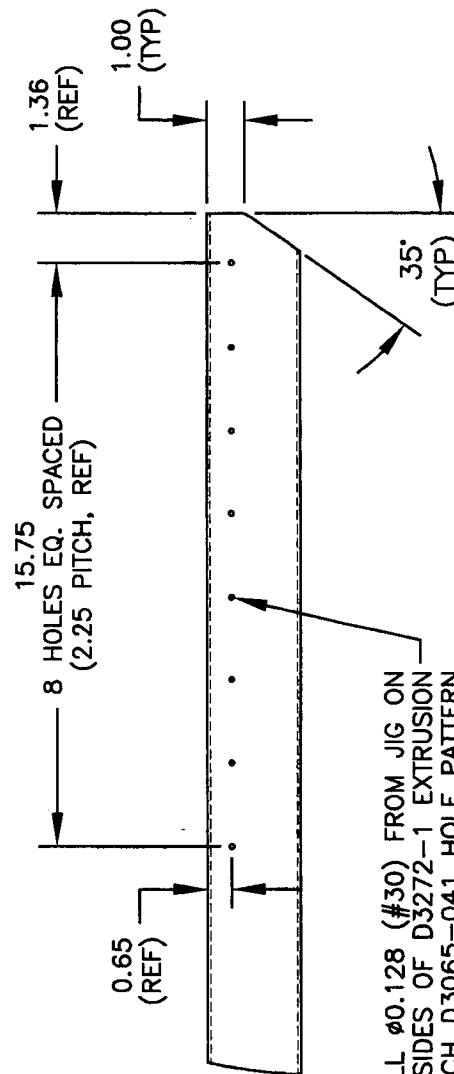
RELEASED

07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8					2	2	D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.